

Work Order ID 69271

Friday, May 06, 2011 8:56:35 AM



Page 1

Item ID: D3836-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 5/6/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: 

Date: 11-05-08 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3836

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3836-2 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

4- weld D3836-2 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

5- weld D2327-3 spacer bushing as per dwg D3836

A/R ER316 S.S. Rod Batch: 115928

6- grind weld flush where indicated on dwg

SAD 11-05-08

②

Pl 11-05-24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Required Date: 5/12/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

11-05-24

2

140 QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/11/15/24

2

242

150 Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

3AD

11-05-24

2

W/O:		WORK ORDER CHANGES						
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Page 3

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Start Date: 5/6/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/2648

CL11105/25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

Picklist Print

Friday, May 06, 2011 8:56:42 AM

Page 1
T

Work Order ID: 69271



Parent Item: D3836-042



Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 5/6/2011

Required Date: 5/12/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:cC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2327-3 		Manufactured	No			100	Each	0.0000	1	2			
Spacer Bushing M304TS0.750W.065 		Purchased	No			100	f	1,447.586	1.7808	3.749053			
304 SQ Tube .75x.75x.065W 													

369436 → ② PL 11-05-24

SAA 11-05-09

Location

Loc Qty

Loc Code

MAT018

1000

117598

1000

WA007

447.5859906

116267

179.684072

116763

267.901919

3.7491

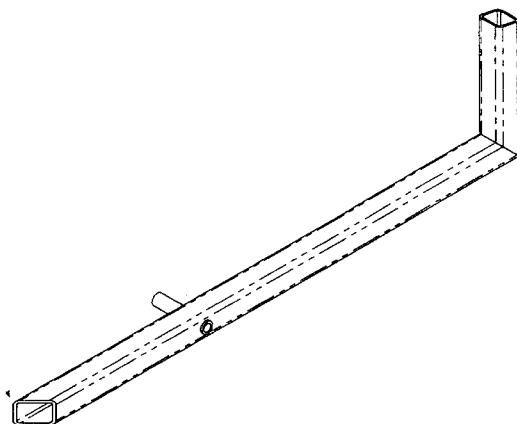
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

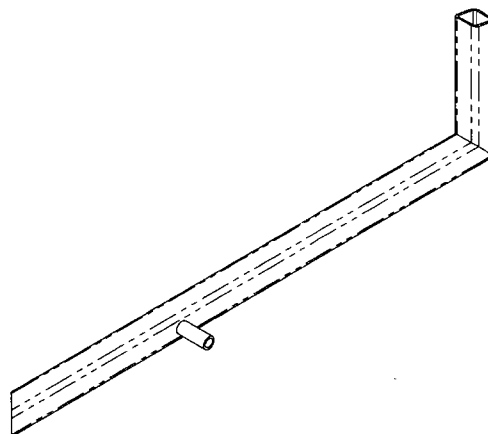
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D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.99 lbs EACH
 - 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

SHOP COPY
RETURN TO
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UNCONTROLLED COPY.
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69271
18-11-05-6

RELEASED
08/11/18 MP

A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3836	REV. A
TITLE RIB ASSY (BASKET LID)	SCALE NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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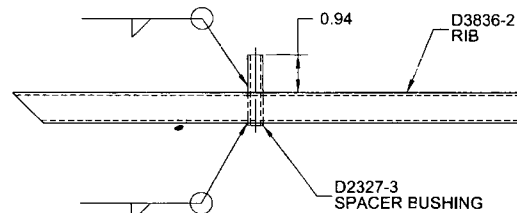
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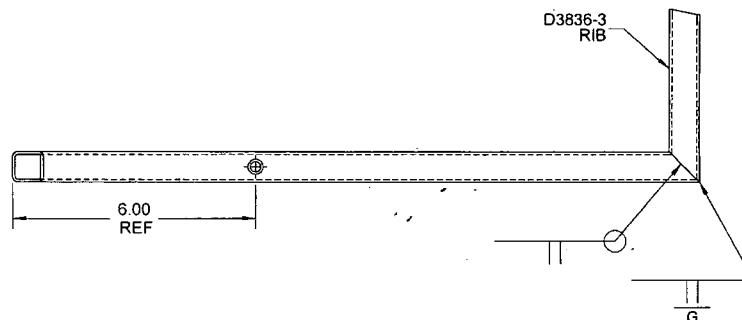
D3836-1
RIB

0.94

D2327-3
SPACER BUSHINGD2327-3
SPACER BUSHING

C

C

D3836-3
RIB6.00
REF

B

B

D3836-041 RIB ASSY (BASKET LID, LH)**D3836-042 RIB ASSY (BASKET LID, RH)**

w/o 49271

RELEASED
08/11/18

A

A

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
DATE	08.09.24	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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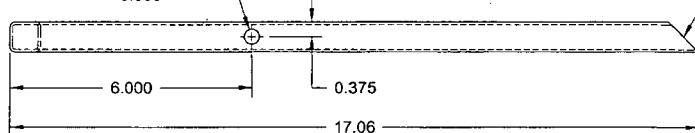
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NOTE: Date & initial all entries

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CHAMFER

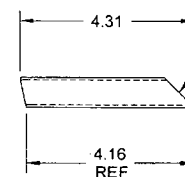


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0.75 X 45°
CHAMFER

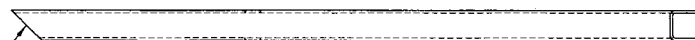
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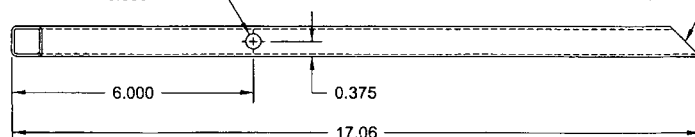
0.75 X 45°
CHAMFER

D3836-3 RIB

0.75 X 45°
CHAMFER

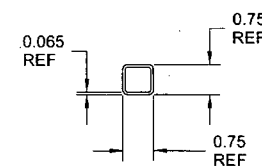


$\varnothing 0.375^{+0.020}_{-0.000}$ THRU



0.75 X 45°
CHAMFER

D3836-2 RIB



**TYPICAL SECTION
VIEW**

RELEASED
08/11/18

u669271

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>ASS</i>	DRAWING NO. D3836 REV. A
MFG. APPR.	<i>AP</i>	SHEET 3 OF 3
APPROVED	<i>AP</i>	TITLE RIB ASSY (BASKET LID) SCALE NTS
DE APPR.	<i>AP</i>	
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